#### Method and apparatus forming tapered sheets, and tape **⊯d** sheets formed therewith

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Cited documents:

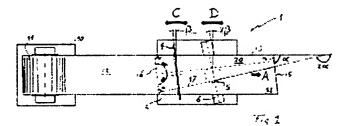
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WO8401728

DE29819243U

### Abstract of EP1138424

The invention relates to a method for forming a tapered sheet for building purposes, in which the tapered sheet is formed from a metal strip. The method is characterised in that the tapered sheet is formed by shearing the metal strip in two places under an angle of alpha with a side of the metal strip and by shearing the metal strip in between these two places under an angle of 2 alpha with the side of the metal strip, the shearing being performed in any order, to form a substantially symmetrical tapered sheet. The invention also relates to an apparatus for forming a tapered sheet for building purposes, to form the tapered sheet from a metal strip. The apparatus is characterised in that it comprises first shearing means so as to be able to make a cross cut under an angle alpha and second shearing means so as to be able to make a substantially longitudinal cut under an angle 2 alpha in the metal strip.



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## **EUROPEAN PATENT APPLICATION**

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# (54) Method and apparatus for forming tapered sheets, and tapered sheets formed therewith

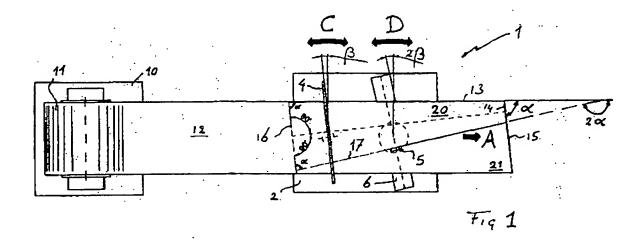
(57) The invention relates to a method for forming a tapered sheet for building purposes, in which the tapered sheet is formed from a metal strip.

The method is characterised in that the tapered sheet is formed by shearing the metal strip in two places under an angle of  $\alpha$  with a side of the metal strip and by shearing the metal strip in between these two places under an angle of  $2\alpha$  with the side of the metal strip, the shearing being performed in any order, to form a sub-

stantially symmetrical tapered sheet.

The invention also relates to an apparatus for forming a tapered sheet for building purposes, to form the tapered sheet from a metal strip.

The apparatus is characterised in that it comprises first shearing means so as to be able to make a cross cut under an angle  $\alpha$  and second shearing means so as to be able to make a substantially longitudinal cut under an angle  $2\alpha$  in the metal strip.



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[0001] The invention relates to a method for forming a tapered sheet for building purposes, in which the tapered sheet is formed from a metal strip. The invention also relates to an apparatus for forming a tapered sheet for building purposes, and a tapered sheet formed therewith.

[0002] Nowadays many buildings, and especially the roofs thereof, are constructed from metal panels. The sides of the metal panels are bent upwards, to form standing seams which are slidably attached to retaining clips.

[0003] When the roofs or walls are straight, it is simple to cut the panels from a metal strip and use them in that form to construct a roof or wall. However, modern buildings are designed with more complex forms, such as conical forms. For such forms straight panels cannot be used, and therefore tapered panels have to be available. [0004] It is known to make tapered sheets for building purposes by cutting a strip perpendicular to the length direction of the strip, in the same way as straight panels are made, and then cutting the sheet lengthwise under an angle. In this way a tapered sheet with two right angles on one side of the tapered sheet is made.

[0005] These tapered sheets have the disadvantage that after the mounting of the sheets on a building, the tapered sheets stick out on the side where the lengthwise cut is made. These protruding ends must be removed, which requires extra work and leads to wastage of the strip material.

[0003] Of course it is known that symmetrical tapered metal sheets can for instance be formed by nibbling, laser cutting or water jet cutting. However, all these methods require expensive machines, which cannot be used on the site where the building is erected, and most important, the length of the tapered sheets thus formed is limited and mostly too short for building purposes.

[0007] It is an objective of the invention to provide a method and apparatus with which substantially symmetrical tapered sheets can be formed in a simple and fast manner.

[0008] It is another objective to provide such a method and apparatus which can be used on the site where a building is erected.

[0009] It is still another objective to provide such a method and apparatus which is easy to use and cheap. [0010] According to a first aspect of the invention, one or more of these objectives is reached with a method for forming a tapered sheet for building purposes, in which the tapered sheet is formed from a metal strip, characterised in that the tapered sheet is formed by shearing the metal strip in two places under an angle of  $\alpha$  with a side of the metal strip and by shearing the metal strip in between these two places under an angle of  $2\alpha$  with the side of the metal strip, the shearing being performed in any order, to form a substantially symmetrical tapered sheet.

[0011] In this asymmetrical tapered sheet is formed by a simple shearing operation, like the shearing or cutting of the straight metal panels, but by cutting the metal strip under an angle of  $\alpha$ , the tapered metal panel is directly given the intended symmetrical form.

[0012] Preferably the method comprises the following successive steps:

- providing a first cross cut in the metal strip by shearing the metal strip under an angle of α with the side of the metal strip;
- transporting the metal strip and shearing the metal strip under an angle of 2x with the side of the metal strip, starting from the first cross cut;
- providing a second cross cut in the metal strip by shearing the metal strip under an angle α with the side of the metal strip, parallel to the first cut;
  - transporting of the metal strip and shearing under an angle of 2α, until the second cross cut is reached.

[0013] After the first cross cut under the required angle α is made the strip is transported, and after a short distance the shearing under the angle of 2α starts from the first cross cut, of course at the required point for the tapered sheet that has to be made. The transporting and the cutting continues until the second cross cut has to be made. For this the strip is preferably stopped, though the transport could go on while the second cross cut is made. Then the shearing under an angle of 2α goes on until the second cross cut is reached and the tapered sheet is finished. In this way, a tapered sheet can be produced in any required length.

[0014] According to a preferred embodiment, the second cross cut is used as the first cross cut for a successive tapered sheet. In this way a successive tapered sheet can be produced directly after the first sheet, without the need for a first cut, and without wastage. Of course this is only possible if the successive sheet requires the same angle  $\alpha$ , but this is often the case.

[0015] Preferably the first and/or second cross cut under an angle of  $\alpha$  are executed by using straight shears or a guillotine, and preferably the shearing under an angle of  $2\alpha$  during transportation is executed with a cutting roll. The cross cuts can be executed very fast with the straight shears or guillotine, and the cutting roll can shear any length of strip and thus cut any required length of tapered sheet.

[0016] An ongoing production of tapered sheets can be realised when the metal strip is provided on roll or coil.

[0017] Preferably, the metal of the metal strip is aluminium.

[0018] According to a second aspect of the invention, an apparatus for forming tapered sheet for building purposes is provided, to form the tapered sheet from a metal strip, characterised in that the apparatus comprises first shearing means so as to be able to make a cross

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cut under an angle  $\alpha$  and second shearing means so as to be able to make a substantially longitudinal cut under an angle  $2\alpha$  in the metal strip.

[0019] With this apparatus, a tapered sheet with any required length can be made, using the method described above.

[0020] Preferably the first shearing means and the second shearing means are adjustable so as to be able to cut the metal strip under different angles. By adjusting the first and second shearing means, it is simple to change the production from tapered sheats with a certain angle  $\alpha$  to tapered sheats with another angle  $\alpha$ .

[6021] According to a preferred embediment, the first shearing means are straight shears or a guillotine, and preferably the second shearing means is a cutting roll so as to shear when the metal strip is moving relative to the cutting roll. The straight shears or the guillotine can make the cross cuts very fast, and the cutting roll can make the substantially longitudinal cut over any required length.

[0022] Preferably, transporting means are provided in the apparatus so as to be able to transport the metal strip through the apparatus.

[0023] According to a preferred embodiment, control means are provided so as to perform the method according to the first aspect of the invention with the use of the apparatus. With the control means, the shearing of the first and second shearing means and the transportation of the strip can be controlled, so that the tapered sheets can be produced automatically or semi-automatically.

[0024] The invention will be elucidated referring to an exemplary embodiment, in view of the accompanying drawing.

[0025] Fig. 1 shows, in a schematic way, an embodiment of the invention in top view.

[0026] Fig. 2 shows the embodiment of fig. 1 in side view.

[0027] Fig. 1 and 2 show the apparatus 1 according to the invention, consisting of a frame 2 with rollers 3 for the metal strip from which tapered sheets are to be made, and straight shears 4, 4a and a cutting roll 5 on a guide 6. A decoiler 10 supports a coil 11 of the strip material 12 with a side 13, from which the tapered sheets 20 are cut.

[0026] Not shown are the adjusting means for adjusting the angle of the shears 4, 4a and the guide 6 for the cutting roll 5, and neither are the transporting means for transporting the strip 12 through the apparatus 1, and for removing the tapered sheet 20 and the scrap sheet 21 from the apparatus. Of course, supporting means are present for supporting the strip 12 in the apparatus and for supporting the tapered sheet 20 outside the apparatus, but these are also not shown.

[0029] The method for forming a tapered sheet is as follows.

[0030] A first cross cut 15 is made under an angle  $\alpha$  with the side 13 of the strip 12, using the shears 4, 4a.

The shears are placed under an angle  $\beta$  = 90° -  $\alpha$  with the transverse direction of the strip.

[0031] Subsequently the strip is transported in direction A and after a short distance reaches the cutting roll 5, which is placed on the guide 6 such that the top end 14 of the tapered sheat 20 has the required width. The guide 6 is placed under an angle of  $2\alpha$  with the side 13 of the strip, or an angle of  $2\beta$  with the transverse direction. During the further transportation of the strip 12, the side 17 of the tapered sheet 20 is formed by the cutting roll 5, which is guided over the guide 6 so as to form the side 17 under the angle of  $2\alpha$ .

[0032] When the base of the tapered sheet 20 reaches the shears 4, 4a, the transport of the strip is stopped and the strip is cut at the second cross cut 16 using the shears 4, 4a by the reciprocating movement B of shear

[0033] Subsequently the cut-off part is transported further and the cutting roll 5 resumes the cutting of side 17, until the cut-off side 16 is reached and the tapered sheet 20 is finished. At the same time, the scrap sheet 21 is formed. Most times, the sheet 21 will have too small a top end and base to be usable. In exceptional cases, the scrap sheets 21 will also be usable for building purposes.

[0034] After a first tapered sheet is made, the second cross cut 16 under angle  $\alpha$  can be used as first cross cut 15 for the next tapered sheet, so after positioning of the cutting roll 5 on the guide 6 the next sheet can be formed by cutting the side 17.

[0035] The shears 4, 4a and the guide 6 are adjustable in the directions C and D so as to be able to cut tapered sheats with different angles α. It will be possible to connect the shears 4, 4a and the guide 6, so that an adjustment of the shears 4, 4a with an angle γ will always lead to an adjustment of the guide 6 with an angle 2γ. [0036] Due to the simple apparatus according to the invention, which is far shorter than the tapered sheats that are formed with it, the apparatus fits easily in a standard container and can therefore be easily transported to the site where a building is erected for which the tapered sheets are required.

[0037] It will be clear that where in the above a sheet is mentioned, this could also be a plate.

[0038] It will be understood that the invention is not limited to the construction as described above and shown in the figures. For instance, instead of shears 4, 4a a cutting roll could be used, to be moved over a guide that is adjustable as the shears 4, 4a are. And instead of the cutting roll 5 reciprocating shearing means could be used.

#### Claims

 Method for forming a tapered sheet for building purposes, in which the tapered sheet is formed from a metal strip, characterised in that, the tapered

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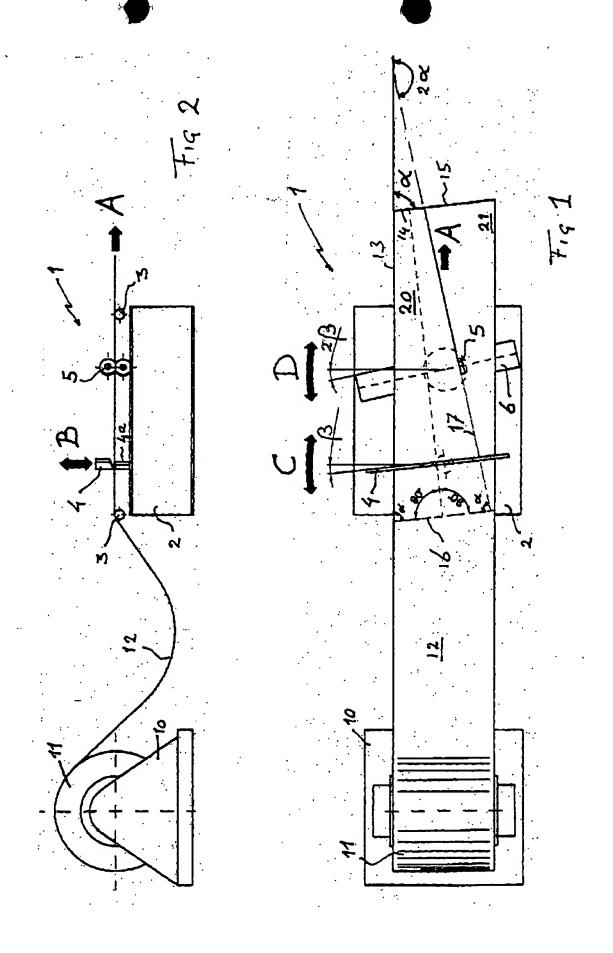
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sheet is formed by shearing the metal strip on two places under an angle of  $\alpha$  with a side of the metal strip and by shearing the metal strip in between these two places under an angle of  $2\alpha$  with the side of the metal strip, the shearing being performed in any order, to form a substantially symmetrical tapered sheet.

- 2. Method according to claim 1, characterised in that, the method comprises the following successive steps:
  - providing a first cross cut in the metal strip by shearing the metal strip under an angle of α with the side of the metal strip;
  - transporting the metal strip and shearing the metal strip under an angle of 2α with the side of the metal strip, starting from the first cross cut:
  - providing a second cross cut in the metal strip by shearing the metal strip under an angle α with the side of the metal strip, parallel to the first cut:
  - transporting the metal strip and shearing under an angle of 2α, until the second cross cut is reached.
- Method according to claim 1 or 2, characterised in that, the second cross cut is used as the first cross cut for a successive tapered sheet.
- 4. Method according to claim 2 or 3, characterised in that, the first and/or second cross cut under an angle of α are executed by using straight shears or a guillotine, and preferably the shearing under an angle of 2α during transportation is executed with a cutting roll.
- Method according to any one of the preceding claims, characterised in that, the metal strip is provided on roll or coil.
- Method according to any one of the preceding claims, characterised in that, the metal of the metal strip is aluminium.
- 7. Apparatus for forming a tapered sheet for building purposes, to form the tapered sheet from a metal strip; characterised in that, the apparatus comprises first shearing means so as to be able to make a cross cut under an angle α and second shearing means so as to be able to make a substantially longitudinal cut under an angle 2α in the metal strip.
- 8. Apparatus according to claim 7, characterised in that, the first shearing means and the second shearing means are adjustable so as to be able to cut the metal strip under different angles.

- Apparatus accessing to claim 7 or 8, characterised in that, the first shearing means are straight shears or a guillotine, and preferably the second shearing means is a cutting roll so as to shear when the metal strip is moving relative to the cutting roll.
- 10. Apparatus according to any one of the claims 7 9, characterised in that, transporting means are provided in the apparatus so as to be able to transport the metal strip through the apparatus.
- 11. Apparatus according to any one of the claims 7 10, characterised in that, control means are provided so as to perform the method according to any one of the claims 1 6 with the use of the apparatus.
- 12. Symmetrical tapered sheet for building purposes, formed by using the method according to any one of the claims 1 6 and/or made by using the apparatus according to any one of the claims 7 11.

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# **EUROPEAN SEARCH REPORT**

Application Number EP 00 20 1159

alegory	Citation of document with in of relevant pass:		Relevant to claim	CLASSIFICATION APPLICATION (I	OF THE
	DE 807 451 C (FAUST		1,7,12	B23D19/06	
	WO 84 01728 A (NOKI) 10 May 1984 (1984-0				
	DE 298 19 243 U (BA) 24 December 1998 (19				
				TECHNICAL FIEL SEARCHED	D8 InlCL7)
				B23D B63H	
	The present search report has b			Constant Constant	
	Place of search THE HAGUE	Pale of completion of the search 4 September 20	1	ghmans, H	
C	ATEGORY OF CITED DOCUMENTS	T ; theory or pri	nciple underlying the i	Invention	
X : parti Y : parti docu	cularly relevant if taken alone outerly relevant if combined with anoth ment of the same category nological background	E : earlier pater after the film er D : document of	it document, but publi	anad on, or	





## ANNEX TO THE EUROPEAN SEARCH REPORT ON EUROPEAN PATENT APPLICATION NO.

EP 00 20 1159

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP life on The European Patent Office is in no wey liable for these particulars which are merely given for the purpose of information.

04-09-2000

Patent document cited in search report			Publication date	Patent family member(s)		Publication date	
DE	807451	С	C	NONE		<u>, I.,</u>	
WO	8401728	A	10-05-1984	FI EP	823704 A 0142498 A	30-04-1984 29-05-1985	
DE	29819243	U	24-12-1998	NONE		*************************************	

O Tor more details about this annex : see Official Journal of the European Patent Office, No. 12/82

らないことがわかる。

以上の最適値をまとめると以下のようになる。
1. 指紋検出プリズム1の角 f。 は、45° 直角プリズム (直角をなす辺の長さ25 mm) を使用し、f。=45°とする。

- 2. 指紋検出プリズム 1 と補正プリズム 8 とがなす角  $\theta$  。は、  $\theta$  。  $=40^{\circ}$  とする。
- 3. 補正プリズム 8 の角  $\phi$  1 は、  $\phi$  1 = 4 5 ° と する。
- 4. 指紋検出プリズム1及び補正プリズム8の材質は、光学部品として一般的なBK7を使用する。
- 反射光線の反射角度 θ 、は、 θ 、 = 4 7° とし、反射光 λ の波長は赤色 L E D の 6 6 0 nmにする。
- 6. レンズ 1 1 の焦点距離 f は、f = 2 5 nmとする。 (この場合、全体の倍率差が 0. 0 0 8 となる)
- 7. 画像の中心倍率mは、m=0.5とする。
- 8. CCD受光面12の長さは、2/3インチC

差の発生が防止される。その結果、指紋登録時と 指紋照合時とで指先の位置がずれても所定数の画 素を一致させて、照合率の低下を未然に防止する ことができる。

又、本実施例の指紋読取装置においては、拡散 板 5 の厚みを指紋検出面 2 に近い側ほど厚く設定したため、指紋検出面 2 に到達する光量が均一化 されるとともに C C D 受光面 1 2 に結像する指紋 画像の明るさも均一化される。従って、パターンマッチングのために映像信号を 2 値化しても指紋 の凹凸を表している映像信号の消失が防止され、実際の指紋に忠実な信号を得ることができる。

尚、本実施例の指紋読取装置は以上のようにして具体的な仕様を決定したが、上記した1項から8項までの項目を適宜変更することで異なる仕様、例えば、倍率差をさらに低減させたりレンズ11の焦点距離fを短くして読取装置の小型化を図ったりすることもできる。

又、上記実施例では拡散板5の厚みを変更する ことで指紋検出面2に到達する光量を均一化した C D 案子を使用するため 6. 4 m とする。

→ その他 A C = B D = D E = D F = 2.5 m , C·D

= 5 m , φ2 = 9.0° 上記のような設定値を決定

した。

本発明者は、以上のように設定した本実施例の 指紋読取装置と補正プリズム 8 を備えない従来の 指紋読取装置とを比較し、実際に得られた画像に おける Q点と S点との倍率差が従来の指紋読取装 置では 0.064倍であったのに対し、本実施例 の指紋読取装置では 0.07倍まで低減された ことを確認した。

このように本実施例の指紋読取装置においては、 指紋検出プリズム 1 とレンズ 1 1 との間に、指紋 検出面 2 からレンズ 1 1 の前側主点 K までの全て の光路長の光軸 X に平行な成分を同光軸 X 上の光 路長とほぼ等しくなるように補正する補正プリズ ム 8 を配設した。

従って、指紋検出面2上の実際の指紋は、その 部位に関係なく全て等しい倍率でCCD受光面1 2上に指紋画像として結像し、指紋画像中の倍率

が、上記したように縦方向と横方向に整列したL ED6の配置密度を指紋検出面2側ほど疎となる ように設定してもよい。

### (発明の効果)

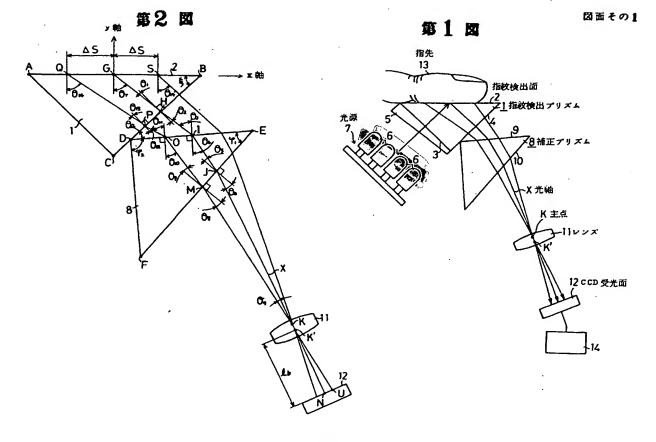
以上詳述したように本発明の指紋読取装置によれば、倍率差の発生を防止して実際の指紋に忠実な指紋画像を得ることができるという優れた効果を発揮する。

#### 4. 図面の簡単な説明

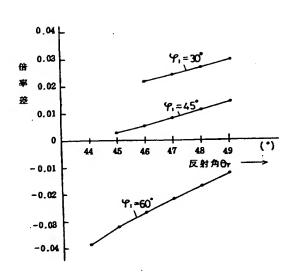
変化を示す図、第11図は実施例の指紋読取装置によって得られた指紋画像を映像信号に変換した 状態を示す図、第12図は平坦な拡散板を用いたり拡散板を用いなかったりした読取装置による映像信号を示す図、第13図は従来の指紋読取装置の概略的な構成を示す図である。

1は指紋検出部材としての指紋検出プリズム、2は指紋検出面、7は光源、8は光学補正部材としての補正プリズム、11はレンズ、12は操像素子としてのCCD受光面、13は指先、Xは光軸、Kは主点。

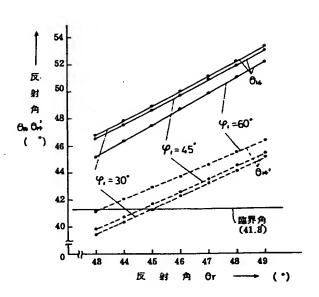
特許出願人 日本電装 株式会社 代理人 弁理士 恩田 博宜(ほか1名)

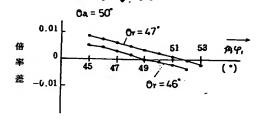


・・・ 図面その2 ・ ほ ー

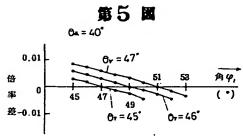


第3 图

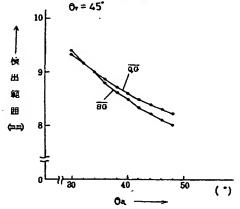


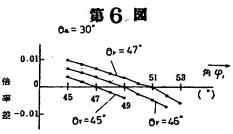


図面その8



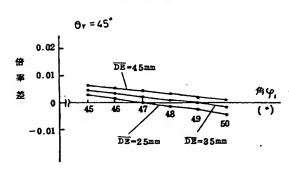
第8図 0r=45



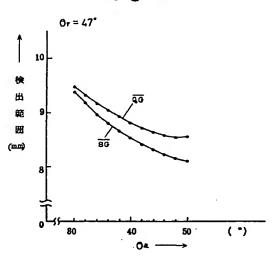


図面その4

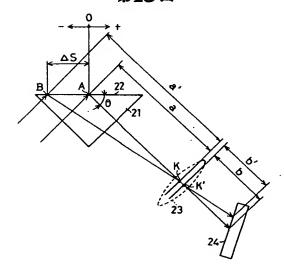
第10図



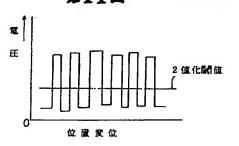
第9図



第13 図



第11回 数图面



第12 図

